



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D5706-3
Job Sheet 195583

Part No: D5706-3 Job Qty: 5 pcs
Part Name: Bracket

Part Weight: 0 lbs Status: New Priority: Medium
Job Created: 5/27/19 Job Tracking No:
Due Date: 6/21/19 Created By: Marie Lajeunesse
Type: SOLD Description:
Note: DWG D5706 REV A8 IPP REV A 19.01.09 NEW ISSUE FK VERIFY DP
Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	HAAS 4 Axis	5 pcs	6/21/19		0.00	1.25	HAAS - 1	52	19/06/08
							HAAS - 2	9.89	
							HAAS - 3		
							HAAS - 4		
110	QC 2	5 pcs	6/21/19		0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52	52	19/06/08
							QC 2 - 57	9.89	
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		



Container No: S188614

Part: D5706-3
Job No: 195583
Serial No/Batch: S188614
Revision: B
Inspector:
Exp Date:
Instructions: Various STC's

Dart Aerospace Ltd.
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Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 06/08/19

NCR: 19-7251
W
W
W

120 QC 8	5 pcs	6/21/19	0.00 0.00	QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	OK 19/10/10
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
125 Handfinish - 1-1 Chemical-B4B	5 pcs	6/21/19	0.00 0.42	QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	JUN 10 2019
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	

127 QC 7	5 pcs	6/21/19	0.00 0.00	Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
				QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	BET 19-06-12
				QC 7 - 60	
				QC 7 - 9	
128 Powdercoat - 1 White G(A)- B4B	5 pcs	6/21/19	0.00 0.50	QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	
				QC 7 - 40	
				QC 7 - 24	
				QC 7 - 43	
				Powdercoat - 1 - B4B	
				Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	
				Powdercoat - 4 - B4B	
129 QC 3	5 pcs	6/21/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	
				QC 3 - 43	
130 Packaging 3-1 - Stock - B4B	5	6/21/19	0.00 0.00	QC 3 - 24	
				Packaging 3 - 1 - B4B	

BET 19-06-12

BET 19-6-10

JUN 13 2019

DAS 40 8-00

DAS 59 9-00

pcs				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	0002 71 NIT
				Packaging 3 - 5 - B4B	
140 QC 21 - SA	5	6/21/19	0.00 0.00	QC 21 - SA - 21	21 JUN 17 2019
	pcs			QC 21 - SA - 70	
Part Op 100 - 1-Machine as per folio FC575 FOLIO REV: <u>B</u> DWG REV: <u>B</u> 2-Debur					
Descriptions: 125 - - Alodine as per DWG					
128 - Mask holes as per DWG note 8. START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M6061T6B1.500X2.500	6061-T6 Bar 1.50 X 2.50	.8350 ft (.187 ea) (2.000)	100-HAAS 4 Axis	5166894	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-HAAS 4 Axis	M6061T6B1.500X2.500	1	20	0	
Part Specifications					
Specifications could not be found.					

120.750 ps
-110.437 ps
10.313 ps
↓
0.859 ft
used

0.859 ft
used

Plex 5/27/19 9:53 AM Dart.lajeunesse.marie

0.859 (used)
-0.835 (Bom)
Scrap=0.024 ft.
+ .167 ft.
[.191]

DART AEROSPACE LTD		Work Order:	195583
Description: Bracket		Part Number:	D57063
Inspection Dwg: D5706		Rev: 3	Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.89	(±).03	.900	✓		Ver	
0.200	(±).01	.200	✓		Ver	
0.550	(±).01	0.548	✓		Ver	
1.25	(±).03	1.25	✓		Ver	
0.25	(±).03	.246	✓		Ver	
0.750	(±).01	0.750	✓		Ver	
R.0.13	(±).03	R.0.13	✓		R.G.	
0.30	(±).03	0.296	✓		Ver	
Ø.204	+0.005 - .001	0.204	✓		G.P.	
0.150	(±).01	0.151	✓		H.G.	
1.13	(±).03	1.127	✓		Ver	
0.175	(±).01	0.175	✓		Ver	
0.775	(±).01	0.775	✓		Ver	
0.780	(±).01	0.780	✓		Ver	
1.090	(±).01	1.091	✓		H.G.	
1.14	(±).03	1.14	✓		Ver	
0.480	(±).01	0.480	✓		H.G.	
R.0.19	(±).03	R.0.19	✓		R.G.	
Ø.257	+0.005 - .001	0.257	✓		G.P.	
R.0.375	(±).01	R.0.375	✓		R.G.	
0.83	(±).03	0.828	✓		Ver	
0.415	(±).01	0.413	✓		Ver	
0.42	(±).03	0.418	✓		Ver	
1.52	(±).03	1.518	✓		H.G.	
65°	(±).5°	65°	✓		A.G.	
R.0.25	(±).03	R.0.25	✓		R.G.	
R.0.13	(±).03	R.0.13	✓		R.G.	

Measured by: ^{DAS} 52	Checked by: 	QC Inspector:
Date: 19/06/08	Date: 19/06/10	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	

Entered: Date: July 5, 2019

NCR No. 19-7251

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only ☐



Job: <u>195583</u>		DISPOSITION		DEPARTMENT/PROCESS							
Part No. <u>DS706-3</u>		Rework ☐ Scrap ☒ Use-as-is ☐		Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Skid-tube ☐ Machining ☒ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐							
Date: <u>19/06/08</u>	Sequence #: <u>1</u>	QTY Affected: <u> </u>		MRB (OS1042) DAS 55 19/06/08 9-89							
Description Work Order Deviation		Disposition									
<u>Error in prog resulting in machine stopped and made a groove</u>		<u>Fixed error</u>									
DAS Completed By <u>52</u> 19/06/08 9-89		Lead hand / Supervisor <u> </u> 19/06/08									
QC / QA Coordinator DAS 68 9-89 JUN 13 2019											
Root Cause ☒ Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors		Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled Other/Details: <u> </u>				FAULT CATEGORY Contamination ☐ Misaligned/off center ☐ BOM/Route ☒ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function		Power Loss/Surge ☐ Folio/Program ☒ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up		Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread	